

Date: Thursday, 11/29/2007 11:07:07 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH BRACKET
 Job Number : 36043
 Estimate Number : 10994
 P.O. Number : N/A Part Number : D2583
 This Issue : 11/29/2007 S.O. No. : N/A Drawing Number : D2583 REV. B
 Prsht Rev. : NO Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 33893 Material : N/A
 Due Date : 12/6/2007 Qty: 100 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat- in house
 processDM
 Est: D 06.07.21 Waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



13.2516



Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/B) 0.040" thick
 (M5052H32S040)

Batch: 104921 IB 07-12-04

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2583

Dwg Rev: B

Prog Rev: B

IB 07-12-4

(108)

2-Deburr if necessary

IB 07-12-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counts
 07/12/06 (108)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

07/12/06 (108)
 SB 07/12/19

(108)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 8/12/21

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:07:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 36043

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



24.12.19



Comment: INSPECT WORK TO CURRENT STEP

QSP019

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M

07.12.20

X108

8.0

POWDER COATING

POWDER COATING



M 106379



108X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/12/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



108

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL

07-12-20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 222

1/12/20

50

108

11.0

QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

28/12/21

Job Completion



2007/12/24

U

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

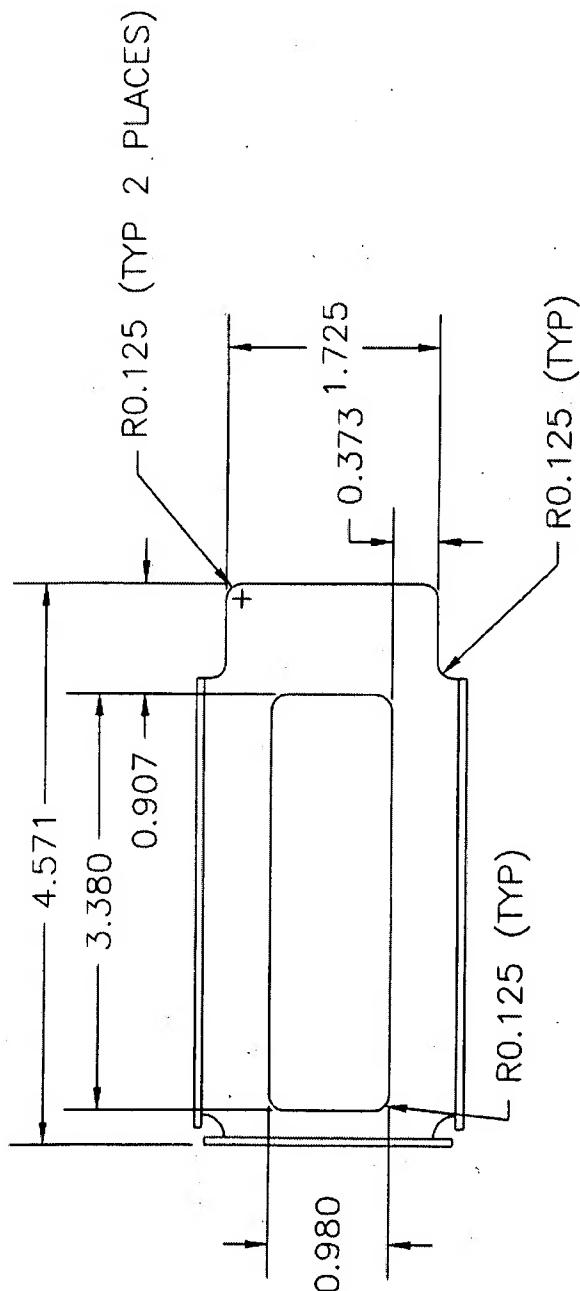
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

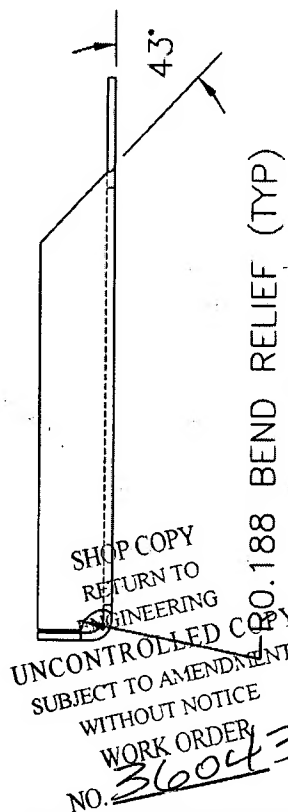
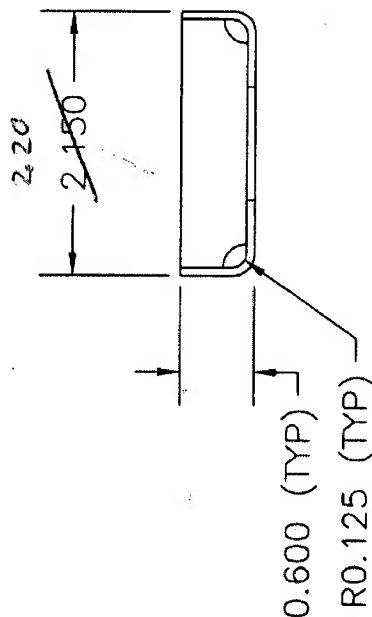


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|-------------------|------------------------|---|------------------------|
| DESIGN MIKE M. | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CP | APPROVED KE | DRAWING NO. D2583 | REV. B SHEET 1 OF 1 |
| DATE 99.02.22 | TITLE LATCH BRACKET | | SCALE 2:3 |
| A | 96.07.10 | NEW ISSUE | |
| B | 99.02.22 | CHANGE OF FINISH (PER TSR A887) | |

RELEASED
KE 99.02.25



KE 99.02.26



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

